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RECORDED

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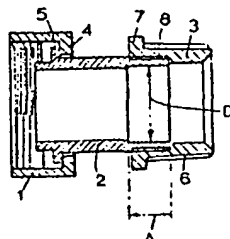
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(54) IMPROVEMENTS IN PIPE UNIONS

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20 of the tub
member by
co-operation
between the
flanges of
the nut and
the tubular
member on
tightening
of the union
25 nut onto
the first member, and a
further metallic member
secured to
the other end
of the tubular
member and
adapted to
screw-threadedly
engage with
30 the second
screw-threaded
member, the
union nut being
held captive
on the tubular
member by the
flange on the
tubular member
and said further
member which
has a sufficiently
large transverse
dimension to
prevent passage
of the union
nut over said
further member.
35 Unions of this
kind have been
used for connecting
gas appliances
together, for
connecting a
meter service
governor to a
meter for example.
It is known to
connect the tubular
40 member to said
further member
after assembly
of the union
nut onto the
tubular member
by screwing
and brazing the
tubular member
to said further
member.
This is, however,
an expensive
operation, requires
45 testing of the
seal between
the two members,
and has a high
reject rate. Moreover
the seal between
the two members
may be broken
when the union is

SPEY Q67 *A1007Y/01 *GB 1460-864
Mfg. pipe union for incompatible threaded members - by threading
tubular member, fitting union nut, screwing end member on and
deforming threaded joint
SPERRY & CO LTD 14.03.74-GB-011308
(06.01.77) F16L-19
A pipe union for two incompatible threaded members is
formed from a stamped union nut (1) held captive on a stamped
and machined tubular member (2) secured to a forged member (3).
The nut is tapped and the member (3) has an external tapered thread (6).
The union is formed by first forming a thread on one end of the tubular
member (2) and then passing the nut over this end. The member (3) is
then screwed onto the tubular member and a ball plunger or roller
burnishing tool inserted to expand the joint to bind the threads of the
joint together to form a gas tight seal. 13.6.75 (4pp)



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the further
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applied to 65
per at said
other end is
formed with
an external
screw thread
for engagement
with a co-operating
internal screw
thread formed
in said further
member. 70
Usually the
further member
will be formed
with an external
radially extending
polygonal flange
for engagement
by a spanner
when the further
member is
tightened in
use to the second
member. It is
this polygonal
flange which
would prevent
assembly of
the union nut
onto the tubular
member if the
tubular member
were to be
made integral
with the further
member. 80
The tubular
member and the
further member
may be made
of any suitable
metal but preferably
they are made
of brass.
The expansion
of the joint
between the
tubular member
and the further
member is
conveniently
performed by
cold forming
with a ball
plunger or
roller burnishing
tool. 85
The invention
will now be
further described,
by way of example
only, with reference
to the accompanying
drawing which
is an axial cross
section of a
completed brass
union adapted
to secure an
externally screw-
threaded first
member to an
internally screw-
threaded second
member to provide
fluid communication
therebetween. 95

The union comprises a stamped union nut 1 held captive on a stamped and machined tubular member 2 secured to a further member 3 which is a forging.

5 The union nut 1 is internally screw-threaded for engagement with external screw threads on a first member, not shown, and is provided with an internal radial flange 4 for engagement with an external radial flange 5 which is an integral part of one end of the tubular member 2. When the union nut 1 is screwed in use onto the first member the tubular member 2 is drawn towards the first member by the engagement between the flanges 4 and 5.

15 The further member 3 is formed with an external tapered screw thread 6 for engagement with an internal co-operating screw thread of a second member, not shown, and is provided with an integral polygonal radial flange 7 for engagement by a spanner during tightening in use of the further member 7 to the second member.

20 Initially the other end 8 of the tubular member 3 comprises a plain sleeve. Prior to assembly of the union nut 1 onto the sleeve the exterior of said other end 8 is formed with a plain external screw thread for engagement with a complementary screw thread formed internally of the further member 3. The union nut is then assembled onto the tubular member 2 by passing it over said other end 8 of the tubular member. The tubular member and the further member are then screwed together and a ball plunger or roller burnishing tool is inserted into the joint between the members by passing it through the further member 3, and the joint between the members is expanded radially over the distance A by cold forming to increase the internal diameter D of the joint and to bind the screw threads of the joint together to form a gas-tight seal between the tubular member 2 and the further member 3.

45 In one example the initial diameter D is 0.875 inches and a plunging tool of 0.925" diameter is used. The diameter D is thus increased by slightly more than 4% of its initial value.

50 In order to increase the break-loose torque of the joint between the members 2 and 3 a drop of a screw-thread locking material such as that sold under the Registered Trade Mark 'LOCTITE' STÜDLOCK (OR GRADE 75) is applied to the middle part of one of the screw threads before the members 2 and 3 are screwed together.

WHAT WE CLAIM IS:—

1. A method of manufacturing a pipe union of the kind set forth comprising forming said other end of the tubular member and said further member with complementary screw threads, assembling the union nut onto the tubular member by passing it over said other end of the tubular members, screwing said tubular member to said further member, and then permanently deforming the screw-threaded joint between said tubular member and said further member by expanding the joint radially.

2. The method according to claim 1 in which the tubular member is formed with its screw thread prior to assembling the union nut onto the tubular member.

3. The method according to claim 1 or claim 2 in which prior to screwing the tubular member to said further member screw-thread locking material is applied to at least one of the co-operating screw threads.

4. The method according to any of the preceding claims in which the co-operating screw threads comprise an external screw thread formed on the tubular member and an internal screw thread formed on said further member.

5. The method according to any of the preceding claims in which the expansion of the joint is performed by cold forming.

6. The method according to claim 5 in which the joint between the tubular member is expanded by insertion of a ball plunger.

7. The method according to claim 5 in which the joint between the tubular member is expanded by a roller burnishing tool.

8. The method according to any of the preceding claims in which the tubular member and said further member are of brass.

9. The method according to any of the preceding claims in which the internal diameter of the joint between the tubular member and said further member is increased by more than four per cent of the initial diameter.

10. The method according to claim 1 and substantially as described with reference to the accompanying drawing.

11. A pipe union of the kind set forth produced by the method according to any of the preceding claims.

12. A pipe union of the kind set forth manufactured according to the method of claim 10 and substantially as described with reference to the accompanying drawing.

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The union comprises a stamped union nut 1 held captive on a stamped and machined tubular member 2 secured to a further member 3 which is a forging.

5 The union nut 1 is internally screw-threaded for engagement with external screw threads on a first member, not shown, and is provided with an internal radial flange 4 for engagement with an external radial flange 5 which is an integral part of one end of the tubular member 2. When the union nut 1 is screwed in use onto the first member the tubular member 2 is drawn towards the first member by the engagement between the flanges 4 and 5.

15 The further member 3 is formed with an external tapered screw thread 6 for engagement with an internal co-operating screw thread of a second member, not shown, and is provided with an integral polygonal radial flange 7 for engagement by a spanner during tightening in use of the further member 7 to the second member.

20 Initially the other end 8 of the tubular member 3 comprises a plain sleeve. Prior to assembly of the union nut 1 onto the sleeve the exterior of said other end 8 is formed with a plain external screw thread for engagement with a complementary screw thread formed internally of the further member 3. The union nut is then assembled onto the tubular member 2 by passing it over said other end 8 of the tubular member. The tubular member and the further member are then screwed together and a ball plunger or roller burnishing tool is inserted into the joint between the members by passing it through the further member 3, and the joint between the members is expanded radially over the distance A by cold forming to increase the internal diameter D of the joint and to bind the screw threads of the joint together to form a gas-tight seal between the tubular member 2 and the further member 3.

45 In one example the initial diameter D is 0.875 inches and a plunging tool of 0.925 inch diameter is used. The diameter D is thus increased by slightly more than 4% of its initial value.

50 In order to increase the break-loose torque of the joint between the members 2 and 3 a drop of a screw-thread locking material such as that sold under the Registered Trade Mark 'LOCTITE' STULOCK (OR GRADE 75) is applied to the middle part of one of the screw threads before the members 2 and 3 are screwed together.

WHAT WE CLAIM IS:—

60 1. A method of manufacturing a pipe union of the kind set forth comprising forming said other end of the tubular member and said further member with complementary screw threads, assembling the union nut onto the tubular member by passing it over said other end of the tubular members, screwing said tubular member to said further member, and then permanently deforming the screw-threaded joint between said tubular member and said further member by expanding the joint radially.

70 2. The method according to claim 1 in which the tubular member is formed with its screw thread prior to assembling the union nut onto the tubular member.

75 3. The method according to claim 1 or claim 2 in which prior to screwing the tubular member to said further member screw-thread locking material is applied to at least one of the co-operating screw threads.

80 4. The method according to any of the preceding claims in which the co-operating screw threads comprise an external screw thread formed on the tubular member and an internal screw thread formed on said further member.

85 5. The method according to any of the preceding claims in which the expansion of the joint is performed by cold forming.

90 6. The method according to claim 5 in which the joint between the tubular member is expanded by insertion of a ball plunger.

95 7. The method according to claim 5 in which the joint between the tubular member is expanded by a roller burnishing tool.

100 8. The method according to any of the preceding claims in which the tubular member and said further member are of brass.

105 9. The method according to any of the preceding claims in which the internal diameter of the joint between the tubular member and said further member is increased by more than four per cent of the initial diameter.

110 10. The method according to claim 1 and substantially as described with reference to the accompanying drawing.

115 11. A pipe union of the kind set forth produced by the method according to any of the preceding claims.

12. A pipe union of the kind set forth manufactured according to the method of claim 10 and substantially as described with reference to the accompanying drawing.

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